Hub Installation Procedure

PREPARATION

Preparation - clean shaft, install keyway, and verify the correct hub

1 Clean pump shaft

Ensure the shaft is free of debris from transportation. Clean the shaft with cleaning solvent.

2 Install keyway

Install the 28 mm wide x 16 mm high keyway in the pump shaft.

3 Inspect hub

Verify the hub has QTY 4 set screw holes before installation.

Hub selection

UE-HUB - 1710 Hub / UE Blenders
WD-Drive-Hub - 1810 Hub / Most Blenders
WD-Hub-S/S - 1880 Hub / S/S Blender

Confirm 4 set screw holes

Required tools

Dead blow hammer | 1/4 in. Allen wrench | Torque wrench capable of 62.5 ft-lb

Hub Installation Procedure

HUB INSTALLATION

Hub installation - apply retaining compound, install the hub, and seat it flush

4 Apply Loctite 648

Prep the pump shaft for the hub using Loctite 648 High Strength Retaining Compound.

5 Install hub

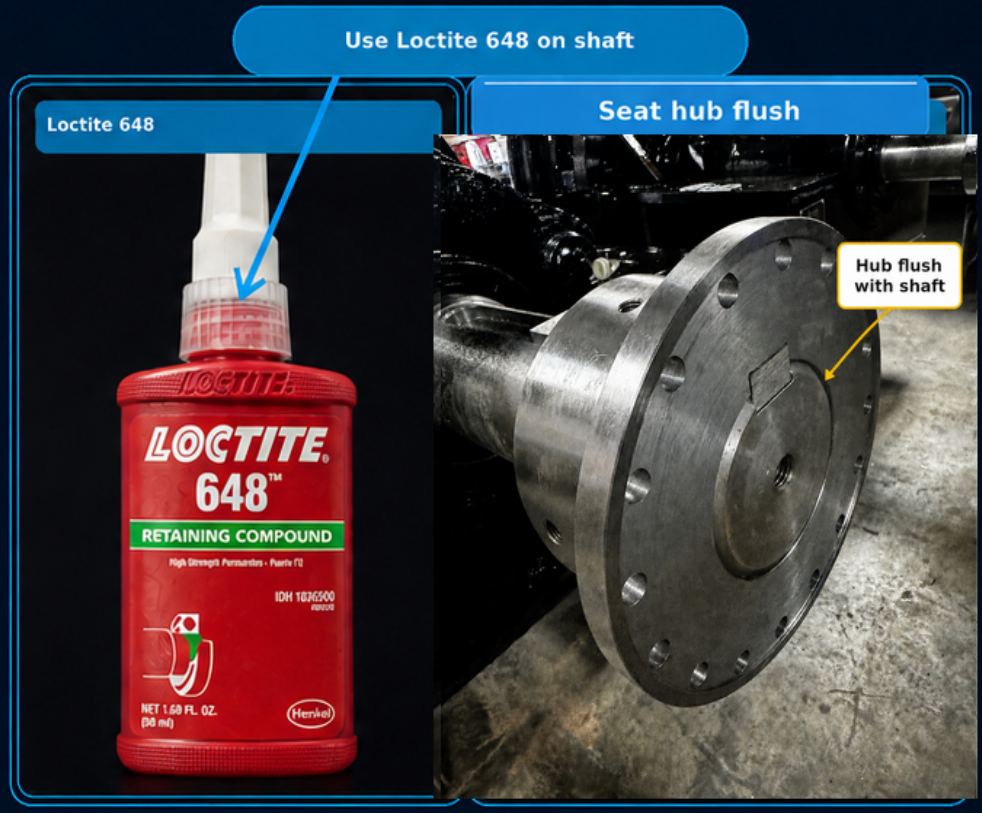
Install the hub using a dead blow hammer.

6 Seat hub flush

Ensure the hub is flush with the end of the shaft.

Installation reminder

Apply retaining compound before driving the hub onto the shaft. Use the dead blow hammer to install the hub.



Critical check

Do not continue to set screw installation until the hub is confirmed flush with the end of the shaft.

Hub Installation Procedure

SET SCREW INSTALLATION

Set screw installation - apply threadlocker, torque all four screws, and verify torque

7 Apply Blue Loctite

Apply Blue Loctite to all set screws before tightening.

8 Torque set screws

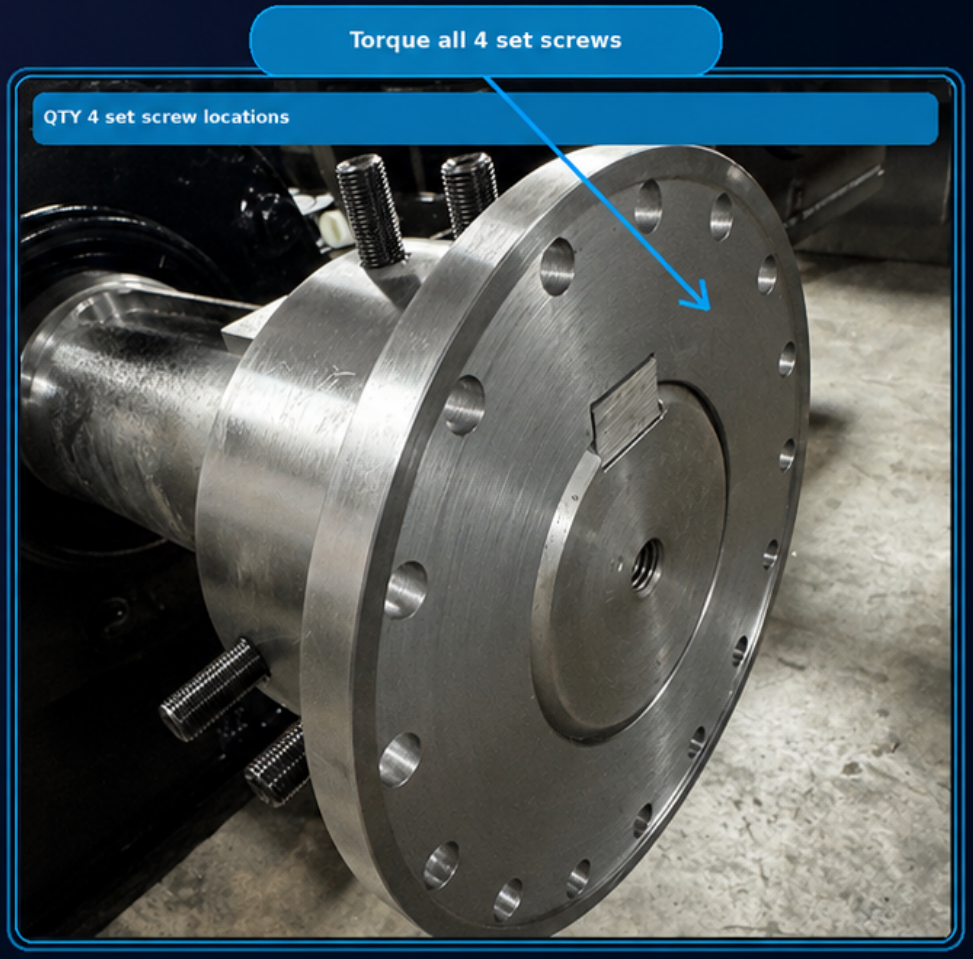
Using a 1/4 in. Allen wrench, tighten the set screws to 62.5 ft-lb.

9 Make a second torque pass

Make a second pass on all set screws to ensure each one is torqued to 62.5 ft-lb.

Fastener specification

QTY 4 set screws - 1/2-20 x 1 1/4 in. Apply Blue Loctite before torque.



Critical reminder

Torque each set screw to 62.5 ft-lb, then make a second pass on all four screws to confirm final torque.

Hub Installation Procedure

FINAL VERIFICATION

Final verification - confirm installation details before returning the pump to service

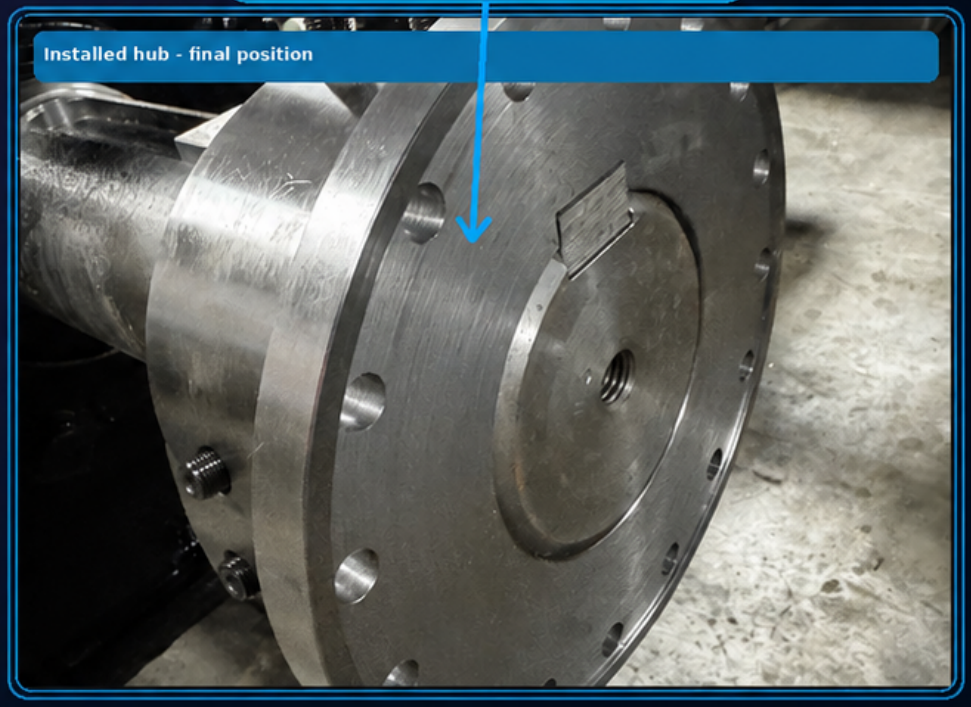
Final installation checklist

- **Keyway installed**
  28 mm wide x 16 mm high
- **Hub installed flush**
  Hub face flush with shaft end
- **Set screw count**
  QTY 4 installed
- **Threadlocker applied**
  Blue Loctite on set screws
- **First torque pass**
  62.5 ft-lb on all 4 screws
- **Second torque pass**
  62.5 ft-lb verified on all 4 screws

Key rule

Flush hub. Four set screws. 62.5 ft-lb. Verify torque twice.

Ready after final torque check



Step 10 - Ready for operation

Once the hub is installed, seated flush, and all four set screws have passed the second 62.5 ft-lb torque check, the installation is complete.